

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2016-96 Date Opened: 28 July 2016 Title: FabricationAircraft OEM: Eurocopter Aircraft Model: AS350 Product Type: Bicycle Rack Product Model: Threaded Bushing Quantity: 40**Work Order Contents**

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JR
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JR
Parts Distribution Sheet	JR
Sub Component Tags	N/A
Completed Certification	DM
Time Sheet (R&D)	N/A
Notes	N/A

**Build Sheet Contents**

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	N/A

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
100226	0	Threaded Bushing	JR

**Traveller**

Initial or N/A


**Component Completion**

	As Instructed
Quantity Complete on This Work Order	40
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

**Certification**

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	DM
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	DM

**Additional Documentation**

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

**Billing**

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Work performed by:

Print: D. Martyn

Sign:

ICC / Dual Inspection performed by:

Print: N/A

Sign:

Work Order closed by:

Print: J. Clarke

Sign:

SCA: AD05

Date: 28-Jul-16

SCA:

Date:

SCA: AD02

Date: 19-Apr-17

Approved Manufacturing Facility 73-04

Form 20.0.03

Rev. Original 23 Sep 2014

**Aero Design Ltd.**  
**Component Fabrication**

100226-01 Threaded Bushing

Work Order Number: 2016-96

Date: 28 Jul 16

Notes:

Set speed to 1030 RPM.

Maximum depth of cut not to exceed .050" per pass

A9 Aluminum cutting fluid or equivalent coolant required

Tasks	SCA
1. Record material PO below	AD-05
2. Cut 3/4" solid round bar 6061-T6 aluminum to 4.125" in length	AD-05
3. Set lathe to <del>1030 RPM</del> 1380 RPM, set collet stop to 2" depth	AD-05
4. Using aluminum inserts, face part.	AD-05
<del>7</del> 7 Using 17/64" drill bore hole 3/4" deep.	AD-05
<del>8</del> 8 Insert 1/4" 28 Helicoil Tap into drill chuck on tail stock	AD-05
<del>9</del> 9 Set lathe to neutral	AD-05
<del>10</del> 10 While rotating part in main chuck, feed tap into part with tailstock unlocked.	AD-05
<del>36</del> Set collet stop to 2" depth	
10. Flip part inserting finished end of part into collet ensuring contact with the collet stop.	AD-05
<del>11</del> 5 Set lathe bed stop to finished part length IAW drawing 100226 Item 01	AD-05
<del>12</del> 6 Face end with a maximum depth of cut not to exceed .050" until contact with lathe bed stop is achieved	AD-05
<del>13</del> 11 Repeat steps <del>5 through 8</del> 7 through 10	AD-05
<del>14</del> 12 Deburr and inspect finish and dimensions of final part.	AD-05
<del>15</del> 13 Tag completed parts IAW Aero Design MPM.	AD-05

Material Purchase Order Number 14092

Batch Quantity 40

2016-96

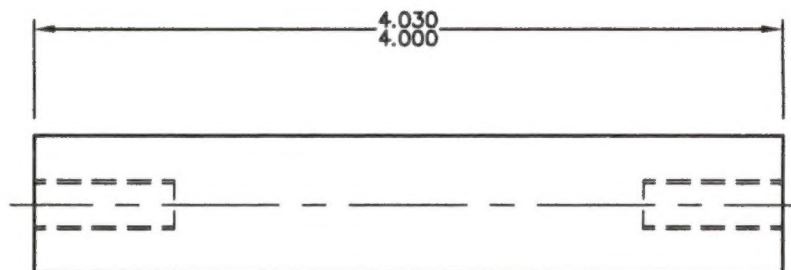
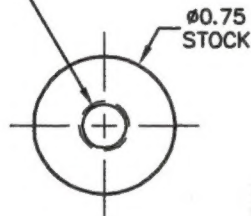
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		


## NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

TAP DRILL  $1\frac{1}{64}$  (0.266) X 0.75 DEEP  
TAP FOR 1/4-28 HELICOIL  
INSTALL 3591-4CN375 HELICOIL  
BOTH ENDS



# (01) RACK BUSHING

2	3591-4CN375	02	SELF-LOCKING HELICOIL			
	100226-01	01	RACK BUSHING	6061-T6 ALUMINUM	QQ-A-200/B	0.75 ROD
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
			APPROVALS	DATE	 <b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2376      www.aerodesign.ca	
			DRAWN: JEFF CLARKE	15 JUNE 2015		
			CHECKED: JASON REKVE	16 JUNE 2015		
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS      ANGLES X.XXX ±0.010      ±1/2° X.XX ±0.03 X.X ±0.1		AIRBUS HELICOPTERS AS350/AS355/EC130 BICYCLE RACK INSTALLATION RACK BUSHING FABRICATION	
			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1	A4	100226	0





WO# 2016-96

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Form 20.F.06

Rev. Original 27 May 2013